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D4151-1
Job Sheet 182380



Part No: D4151-1

Job Qty: 40 ea

Part Name: Lower Hardpoint Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Waterjet		21 18/08/25
100	Waterjet	40 pcs	9/7/18	9/7/18	0.00	1.53	Waterjet1		21 18/08/25
120	QC	40 pcs	9/7/18	9/7/18	0.00	0.00	QC8		DAS AUG 27 2018 68
150	Packaging	40 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3		6 AUG 27 2018 9-89
160	QC21-SA	40 Ea	9/7/18	9/7/18	0.00	0.00	QC21		21 9-89 AUG 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.0320 sf (.0508 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	2	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Hardpoint Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Lower Hardpoint Plate	0.252Inches + 0.003 - 0.000	0.255 0.252	Diameter	
3	Lower Hardpoint Plate	0.375Inches ± 0.010	0.385 0.365		
4	Lower Hardpoint Plate	3.128Inches ± 0.010	3.138 3.118		
5	Lower Hardpoint Plate	1.000Inches ± 0.010	1.010 0.990		
6	Lower Hardpoint Plate	0.500Inches ± 0.030	0.530 0.470		
7	Lower Hardpoint Plate	3.660Inches ± 0.030	3.690 3.630		
8	Lower Hardpoint Plate	2.000Inches ± 0.030	2.030 1.970		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		QTY Effective : _____				MRB (QS1042) Approval			
Description Work Order: _____						Completed By			
						Lead hand / Supervisor Approval Verification			
						QC / QA Coordinator Approval			
Root Cause									
Environment ☐	No R ☐								
Design ☐	Operator ☐								
Doc/Data ☐	Offset/Setup ☐								
Equip/Tooling ☐	Supplier ☐								
Handling/Pre ☐	Training ☐								
Material ☐	Use for Testing ☐								
Internal Transport ☐	Poor Information ☐								
Tribal Knowledge ☐	Rushing ☐								
LOA ☐	Product Improvement ☐								
Substation ☐	Process Improvement ☐								
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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Container No: S105228
Part: D4151-1
Job No: 182380
Serial No/Batch: S105228
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's

Date: 8/25/18

Centre Not CC

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Inspection in

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Loss/Surge

ogram

g Stock Pulled

of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

9	Lower Hardpoint Plate	1.000Inches $\pm$ 0.003	1.003 0.997
10	Lower Hardpoint Plate	0.125Inches $\pm$ 0.010	0.135 0.115

Plex 8/23/18 10:18 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							